

Date: Monday, 18/08/2008 3:30:16 PM  
User: Julie Lecocq

# Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : BEARPAW KIT (19"X16")
<b>Job Number</b> : 41311	
<b>Estimate Number</b> : 12613	
<b>P.O. Number</b> :	<b>Part Number</b> : D120638011
<b>This Issue</b> : 18/08/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2435 REV E1
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : E1
<b>Previous Run</b> : 38141	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 15/09/2008 <b>Qty:</b> 4 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JLD 08.8.18</u>	
<b>Comment</b> : Est Rev:A New Issue 07-01-02 JLM Est Rev:B Added Step 2 08-04-16 JLM Verified By:EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



JLD 08.9.11



**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D120-638-011 CHG 002

508/10/08

2.0	MFG ENGINEERING	MFG ENGINEERING
-----	-----------------	-----------------



**Comment:** MFG ENGINEERING

Program Batch Number

JLD 08.09.19

3.0	MUHMWB10	UHMW 1" Black
-----	----------	---------------



**Comment:** Qty.: 4.6830 sf(s)/Unit Total : 18.7320 sf(s)  
blank: 19.500" x 16.00" x 1.00" thick (+0.030/-0.000) per DSK086-3  
Material: Black UHMW 1"  
(MUHMWB10)  
Batch: M107497

M.A 08/10/07

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



**Comment:** HAAS CNC VERTICAL MACHINING #1

Note: (2) Bearpaw for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2435 Identify as D2435

3-Deburr

M.A 08/10/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 18/08/2008 3:30:16 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X16")

Job Number: 41311

Part Number: D120638011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

H.A 08/10/07

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

WZ 08/10/08

(8)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Pick Packing Kit

8.0

D2182B

Rubber Cushion



Comment: Qty.: 1.6660 f(s)/Unit Total : 6.6640 f(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 D2182B050 (5.00") Rubber Cushion

39986

SS 08/10/08 (4)

9.0

D2274

Radius Block



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2274 Radius Block

2 D2435(ref only) Bearpaw

39238

SS 08/10/08 (4)

10.0

D2438

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2438 Clamp

37852

SS 08/10/08 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 3:30:16 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X16")

Job Number: 41311

Part Number: D120638011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D2529

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2529 Washer 38188

SS 08/10/08 (x4)

12.0

AN415A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN4-15A Bolt M108868

SS 08/10/08 (x4)

13.0

AN960JD416

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN960JD416 Washer M108827

SS 08/10/08 (x4)

14.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4 Nut (or -4) M108145

SS 08/10/08 (x4)

15.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

SS 08/10/08 (x4)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPD120-638-011

Location: Rev A

SS 08/10/08 (x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 3:30:16 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X16")

Job Number: 41311

Part Number: D120638011

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/09 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*u 08/10/09*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DART AEROSPACE LTD		Work Order:	41311
Description: Bearpaw		Part Number:	D2435
Inspection Dwg: D2435	Rev: E1	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.060 x 45°	✓			
B	5.500	+/-0.030	5.500	✓			
C	0.200	+/-0.030	0.199	✓			
D	R0.250	+/-0.030	R0.250	✓			
E	0.250	+/-0.010	0.256	✓			
F	0.625	+/-0.030	0.625	✓			
G	0.25 x 45°	+/-0.030	0.260 x 45°	✓			
H	0.375	+/-0.010	0.380	✓			
I	19.000	+/-0.030	19.000	✓			
J	0.950	+0.030/-0.010	0.955	✓			
K	Ø0.260	+0.005/-0.000	Ø0.260	✓			
L	Ø0.930	+/-0.030	Ø0.929	✓			
M	0.30	+0.030/-0.000	0.310	✓			
N	0.375	+/-0.030	0.385	✓			
O	7.375	+/-0.030	7.370	✓			
P	4.250	+/-0.010	4.250	✓			
Q	2.000	+/-0.030	2.000	✓			
R	9.000	+/-0.010	9.000	✓			
S	15.750	+/-0.030	15.750	✓			

Measured by: M.A	Audited by: <i>ml</i>	Prototype Approval:	N/A
Date: 08/10/07	Date: 08/10/08	Date:	

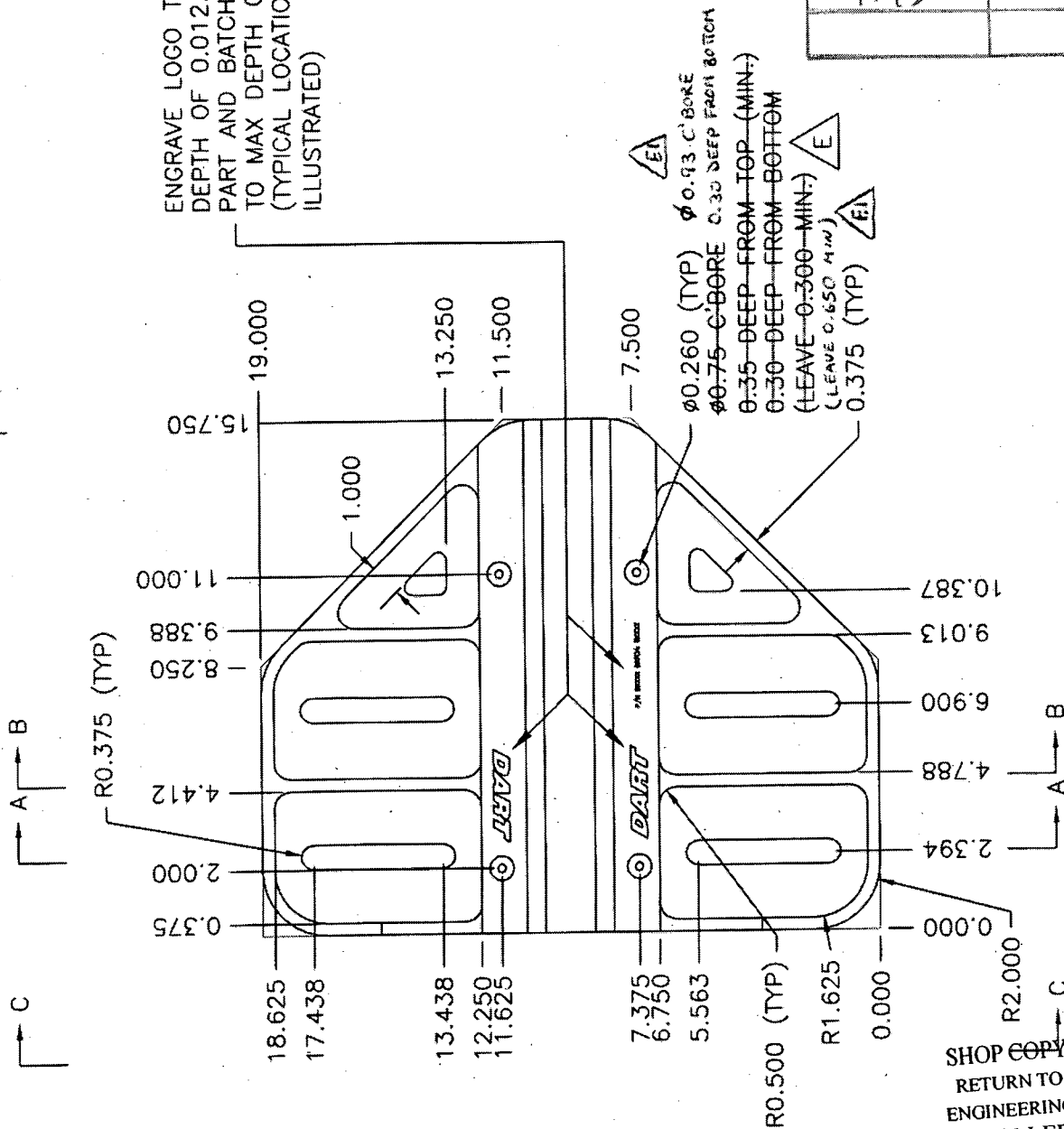
Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10007	KJ/RF <i>17</i>	<i>17</i>



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MB</i>	APPROVED <i>JS</i>	DRAWING NO. D2435	REV. E SHEET 1 OF 2
DATE 98.05.19	TITLE BEARPAW	SCALE 1:5	
A	96.01.24	NEW ISSUE	
B	96.03.26	CHANGE BORE AND C'BORE DEPTH	
C	97.05.07	CHANNEL & C'BORE DEPTH CHANGED	
D	97.10.17	R1.5 BORE WAS R2.637 (TSR A469)	
E	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50	

EFFECTIVE DEOS

9143

RELEASED  
98.06.17 KEENGRAVE LOGO TO MAX  
DEPTH OF 0.012. ENGRAVE  
PART AND BATCH NUMBERS  
TO MAX DEPTH OF 0.010.  
(TYPICAL LOCATION AS  
ILLUSTRATED)MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00 THICK (MACHINE TO 0.950)

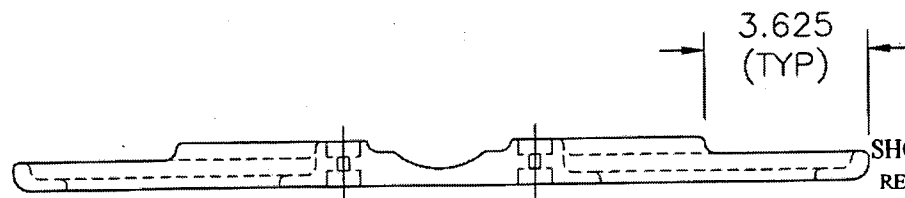
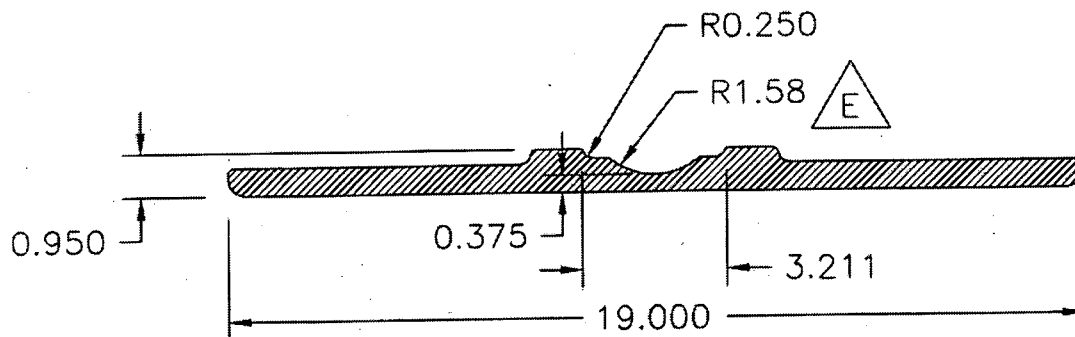
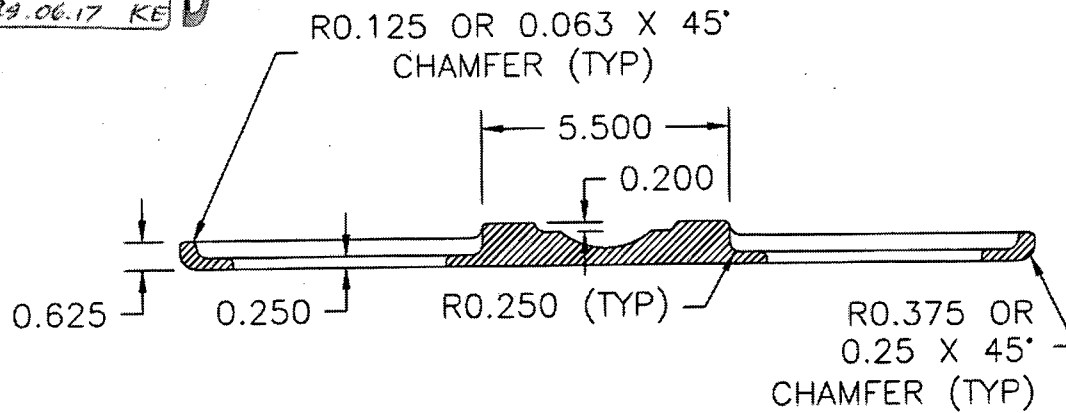
Copyright 1996 by DART AEROSPACE LTD.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 41311



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>DJB</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

RELEASED  
98.06.17 KE



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 41311